

Work Order ID 133535

Tuesday, June 09, 2015 2:22:13 PM

133535

Page 1

Item ID: D066-1003-011L08 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: R66 Cabin Floor Protector - Clear
 Start Date: 6/9/2015 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 6/9/2015 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: JUN 09 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D066-1003	B	JA							
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D066-1003-011L08 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

27
JUL 21 2015

27 J.A JUL 06 2015

27
JUL 21 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Work Order ID 133535

Tuesday, June 09, 2015 2:22:13 PM

133535

Page 2

Item ID: D066-1003-011L08

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: R66 Cabin Floor Protector - Clear

Stop ***NS2***

Start Date: 6/9/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/9/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D066-1003-011L08 Location : FG117								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

Fe 17

SRP
15/7/31

15/7/31

20150731

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : ☐																									

Picklist Print

Tuesday, June 09, 2015 2:22:17 PM

Page 1

Work Order ID: 133535

133535

Parent Item: D066-1003-011L08

D066-1003-011L08

Parent Item Name: R66 Cabin Floor Protector - Clear

Start Date: 6/9/2015

Required Date: 6/9/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.02.05 NEW ISSUE DD VERF:JLM IPP Rev. B
14/07/02 Parts list updated. DL IPP REV:C 15.02.1 AS
PER IIN REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3580-3		Manufactured	No				Each	9.0000	6	12			
D3580-3													
Joggle Bracket DAS													
27 X2													
9-89													
<u>Location</u>													
ST050													
<u>Loc Qty</u>													
9													
<u>Loc Code</u>													
125083													
9													
Each													
131.0000													
6													
12													
J.A													
J.A													
JUL 06 2015													

MS21059L3		Purchased	No				Each	131.0000	6	12			
MS21059L3													
Nut Plate													
<u>Location</u>													
CA													
16													
M129682													
16													
GA													
1													
113749													
1													
ST303													
114													
114													
Each													
0.0000													
1													
2													
J.A													
J.A													
JUL 06 2015													

D4941-1L08		Manufactured	No				Each	0.0000	1	2			
D4941-1L08													
Floor Protector, Fwd LH, (Clear)													
27 X2													
9-89													
D4941-2L08		Manufactured	No				Each	0.0000	1	2			
D4941-2L08													
Floor Protector, Fwd RH, (Clear)													
27 X2													
9-89													
D4941-3L08		Manufactured	No				Each	0.0000	1	2			
D4941-3L08													
Floor Protector, Aft LH, (Clear)													
27 X2													
9-89													
<u>Location</u>													
M131616													
133538													
133537													
133539													
J.A													
J.A													
JUL 06 2015													

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER :																					

Picklist Print

Tuesday, June 09, 2015 2:24:01 PM

Page 2

Work Order ID: 133535

133535

Parent Item: D066-1003-011L08

D066-1003-0111 08

Parent Item Name: R66 Cabin Floor Protector - Clear

Start Date: 6/9/2015

Required Date: 6/9/2015

Start Qty: 2.00

Required Qty: 2.00

D4941-4L08

Manufactured No

Each 0.0000

2 (2) J.A

D4941-4L08

Floor Protector, Aft RH, (Clear)

AN525-10R8

Purchased No

Each 58.0000

6 12 (2) J.A

AN525-10R8

Screw

DAS
27
9-89

X2

Location

Loc Qty

Loc Code

ST329

58

m129163

58

Each 4,239.000

12 24 J.A.

MS20426AD3-4

Purchased No

MS20426AD3-4

RIVET

DAS
27
9-89

X2

Location

Loc Qty

Loc Code

CA

12

125578

12

GA

3801

m131697

3801

MF4

7

125578

7

ST313

419

m127432

419

J.A JUL 06 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

JUL 21 2015

4.0 WEIGHT AND BALANCE

The following is the weight increase associated with the D066-1003-XXX kits. Be sure to subtract the weight of any parts removed.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D066-1003-011L02 Cabin Floor Protector (Black Lexan Sheet)	6.7 lb 3.0 kg	0.10 in 0.00 m	0.67 in-lb 0.00 m-kg	43.72 in 1.11m	293 in-lb 3.33 m-kg
D066-1003-011L08 Cabin Floor Protector (Clear Lexan Sheet)	6.7 lb 3.0 kg	0.10 in 0.00 m	0.67 in-lb 0.00 m-kg	43.72 in 1.11m	293 in-lb 3.33 m-kg
D066-1003-013 Baggage Compartment Protectors	16.5 lb 7.5 kg	3.29 in 0.08 m	54 in-lb 0.60 m-kg	104.35 in 2.65 m	1721 in-lb 19.88 m-kg

5.0 PARTS LIST

Qty -011 L02	Qty -011 L08	Qty -013	Part Number	Description
X			D066-1003-011L02	CABIN FLOOR PROTECTORS (BLACK)
	X		D066-1003-011L08	CABIN FLOOR PROTECTORS (CLEAR)
		X	D066-1003-013	BAGGAGE COMPARTMENT PROTECTORS
1			D4941-1L02	FLOOR PROTECTOR, FWD LH
	1		D4941-1L08	FLOOR PROTECTOR, FWD LH
1			D4941-2 L02	FLOOR PROTECTOR, FWD RH
	1		D4941-2 L08	FLOOR PROTECTOR, FWD RH
1			D4941-3 L02	FLOOR PROTECTOR, AFT LH
	1		D4941-3 L08	FLOOR PROTECTOR, AFT LH
1			D4941-4 L02	FLOOR PROTECTOR, AFT RH
	1		D4941-4 L08	FLOOR PROTECTOR, AFT RH
		1	D4942-1	FLOOR PROTECTOR
		1	D4942-3	FORWARD WALL PROTECTOR
		1	D4942-7	LH WALL PROTECTOR
		1	D4942-9	DOOR PROTECTOR
		2	D4967-1	BRACKET
6	6		D3580-3	JOGGLE BRACKET
		3	D3580-5	JOGGLE BRACKET
		1	D5119-1	PLACARD
		1	D5120-1	PLACARD
6	6		AN525-10R8	SCREW
		10	AN525-10R9	SCREW
		8	CS62-1032-8CR	STUD, CLICK BOND
		3	AN970-3	WASHER
		8	MS21042-3	NUT, SELF LOCKING
		5	CB 200	3.5G ACRYLIC ADHESIVE
6	6	10	MS21059L3	NUTPLATE
12	12	20	MS20426AD3-4	RIVET

Work Order ID 133535

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133535

Page 1

Item ID: D066-1003-011L08

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: R66 Cabin Floor Protector - Clear

Start Date: 6/9/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/9/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJDate: JUN 09 2015

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN-D066-1003

B,

JA

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D066-1003-011L08 CHG002

MLJ JUL 07 2015(2)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

JA JUL 06 2015

QC4- 100% Inspect kits for completeness

0.00

20

Memo

0.00

Quality Control